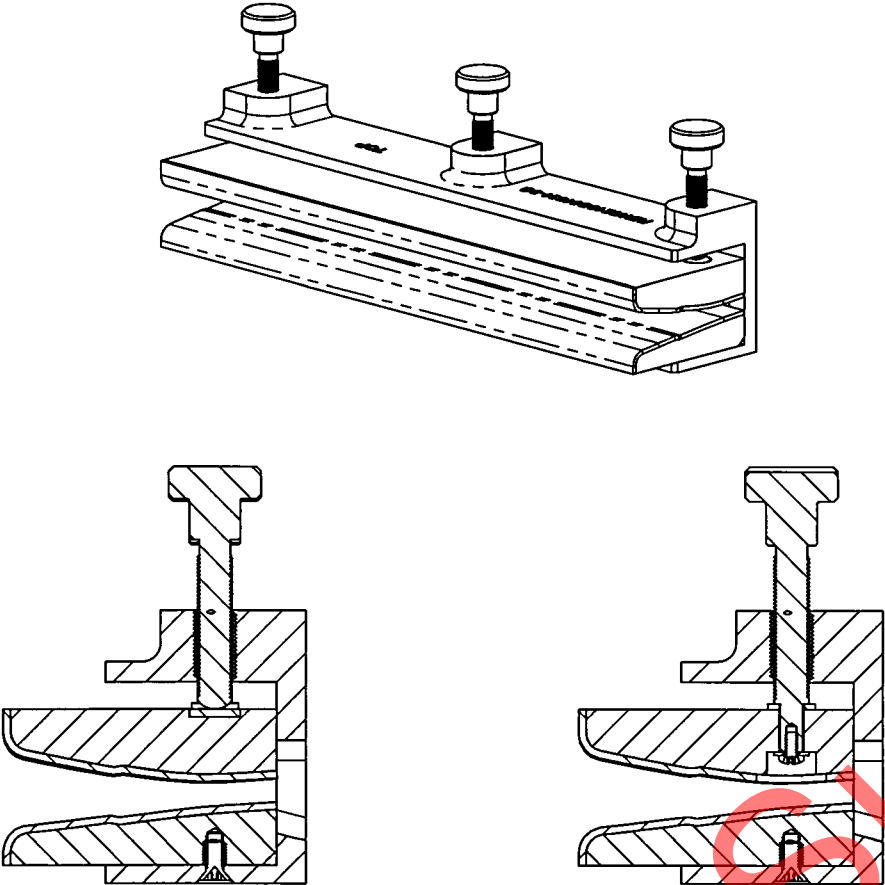


ITEM #	QTY	PART #	PART TITLE
-1	1	RBW6210G01631-8G-1	PUSH SCREW
-2	2	RBW6210G01631-8G-2	LOCKING SCREW
-3	1	RBW6210G01631-8G-3	SUPPORT ASSY
-5	1	RBW6210G01631-8G-5	UPPER PLATE ASSY
-9	1	RBW6210G01631-8G-9	LOWER PLATE ASSY
12	1	McMaster#91400A170 OR EQUIV.	SS PHILLIPS ROUNDED HEAD SCREW #6-40 X 1/4" LG.
13	3	McMaster#91771A829 OR EQUIV.	SS PHILLIPS FLAT HEAD SCREW #10-32 X 1/2" LG.
14	1	McMaster#98017A615 OR EQUIV.	SS WASHER 0.149" ID. X 0.375" OD. X 0.032" THK.
15	1	NAS1149-C0463R	SS WASHER 0.265" ID. X 0.5" OD. X 0.063" THK.

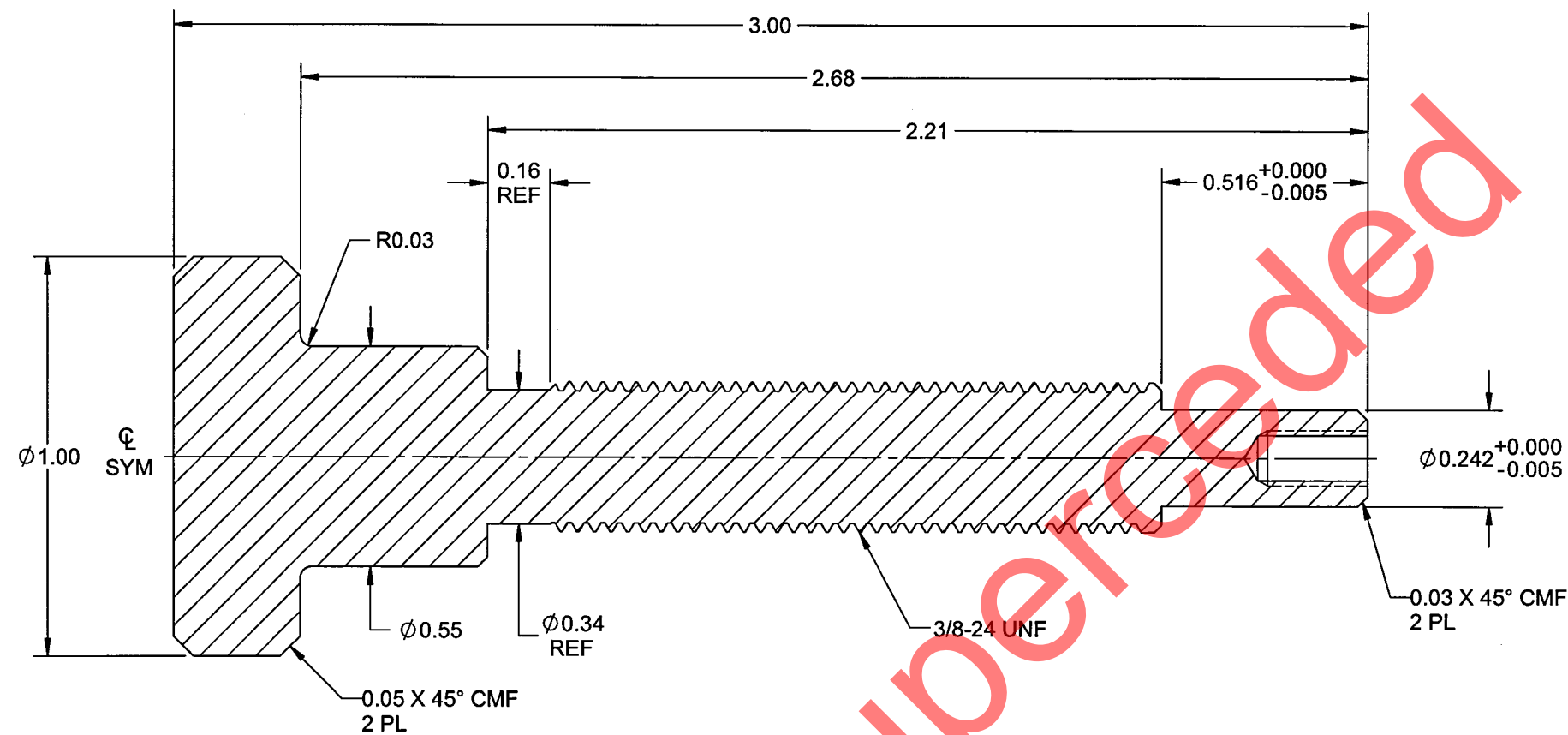


RBW6210G01631-8G M/R BLADE LOCKING PROTECTION TOOL

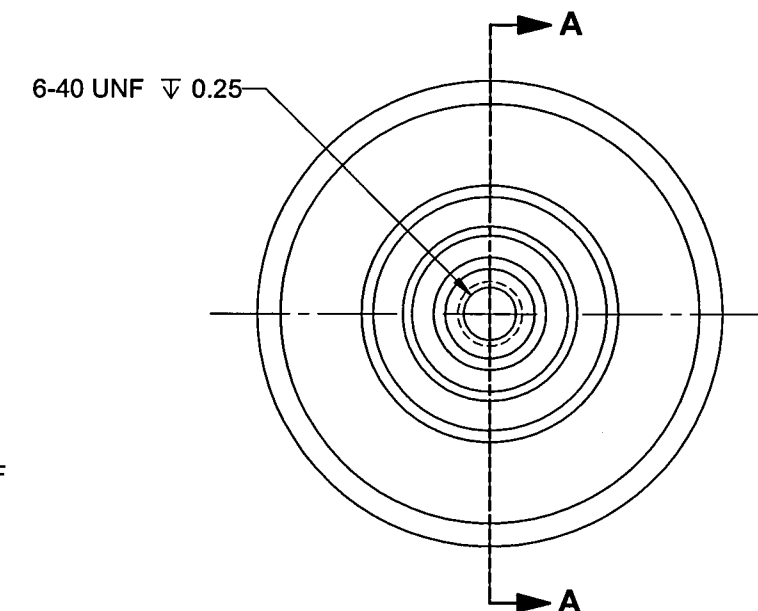
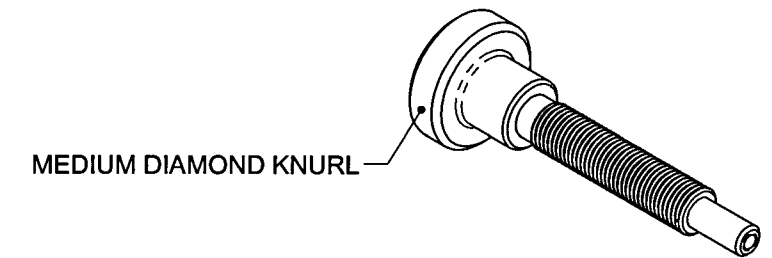
NOTES:

- 1) MATERIAL: N/A
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: N/A
7) IDENTIFICATION: N/A
8) ASSEMBLE AS SHOWN
9) APPLY LOCTITE NICKEL BASED ANTI SEIZE ON THREADS OF ITEM -1 AND ITEM -2 THEN ASSEMBLE WITH ITEM -3
10) APPLY RED THREADLOCKER LOCTITE 263/262 ON THREADS OF ITEM 12 THEN ASSEMBLE WITH ITEM -1 AND REMOVE EXCESS
11) APPLY RED THREADLOCKER LOCTITE 263/262 ON THREADS OF ITEM 13 THEN ASSEMBLE WITH ITEM -9 AND REMOVE EXCESS
12) INSTALL ITEMS 12 AND 13 HANDTIGHT
13) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

A	NEW ISSUE	18-655	KPT
REV.	DESCRIPTION	ECN #	BY
DESIGN	KPT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	FK	RBW6210G01631-8G	SHEET 1 OF 12
APPROVED	VF	TITLE	SCALE
DATE 9/7/2018		M/R BLADE LOCKING PROTECTION TOOL	NTS
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SECTION A-A

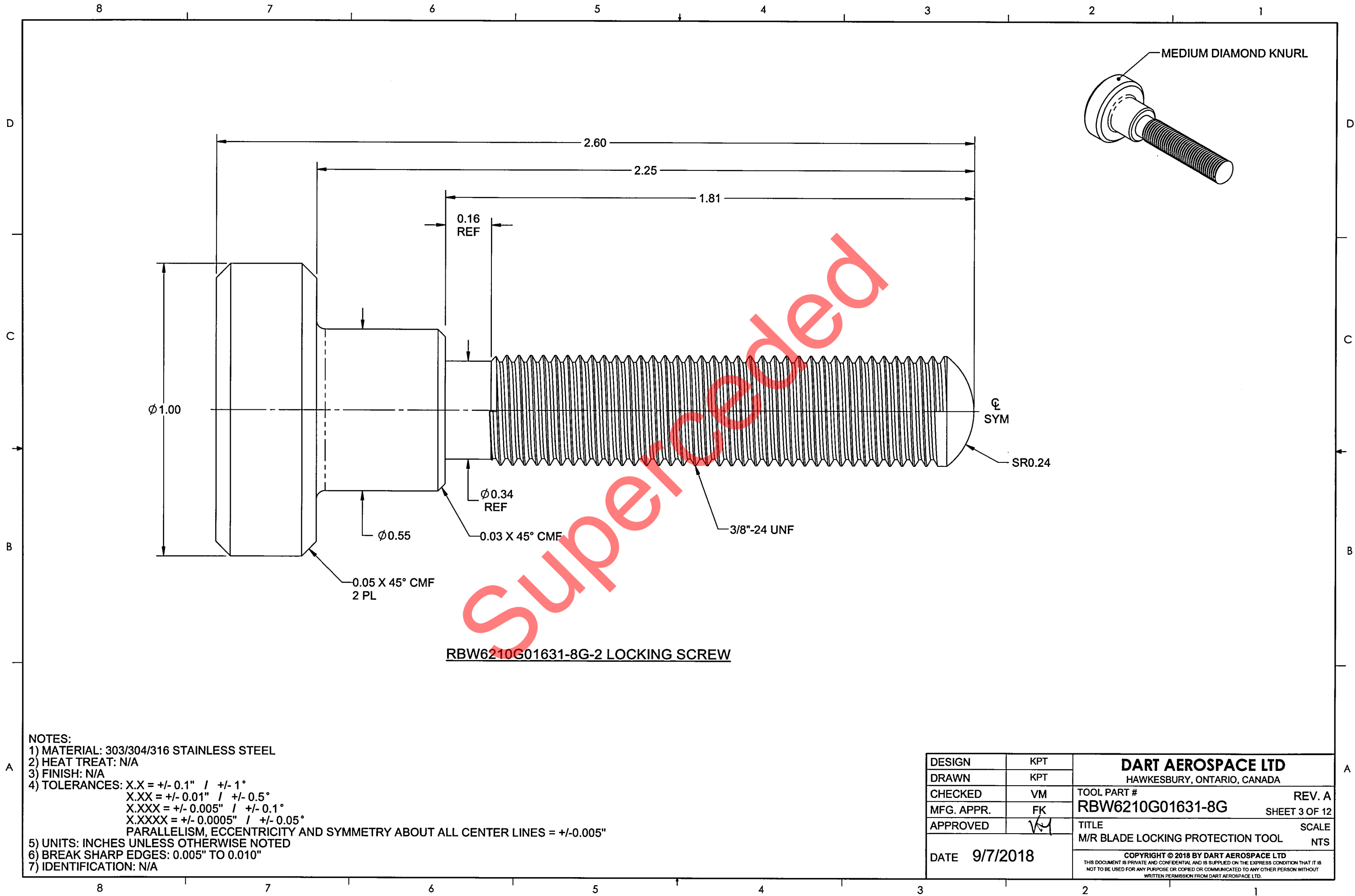


RBW6210G01631-8G-1 PUSH SCREW

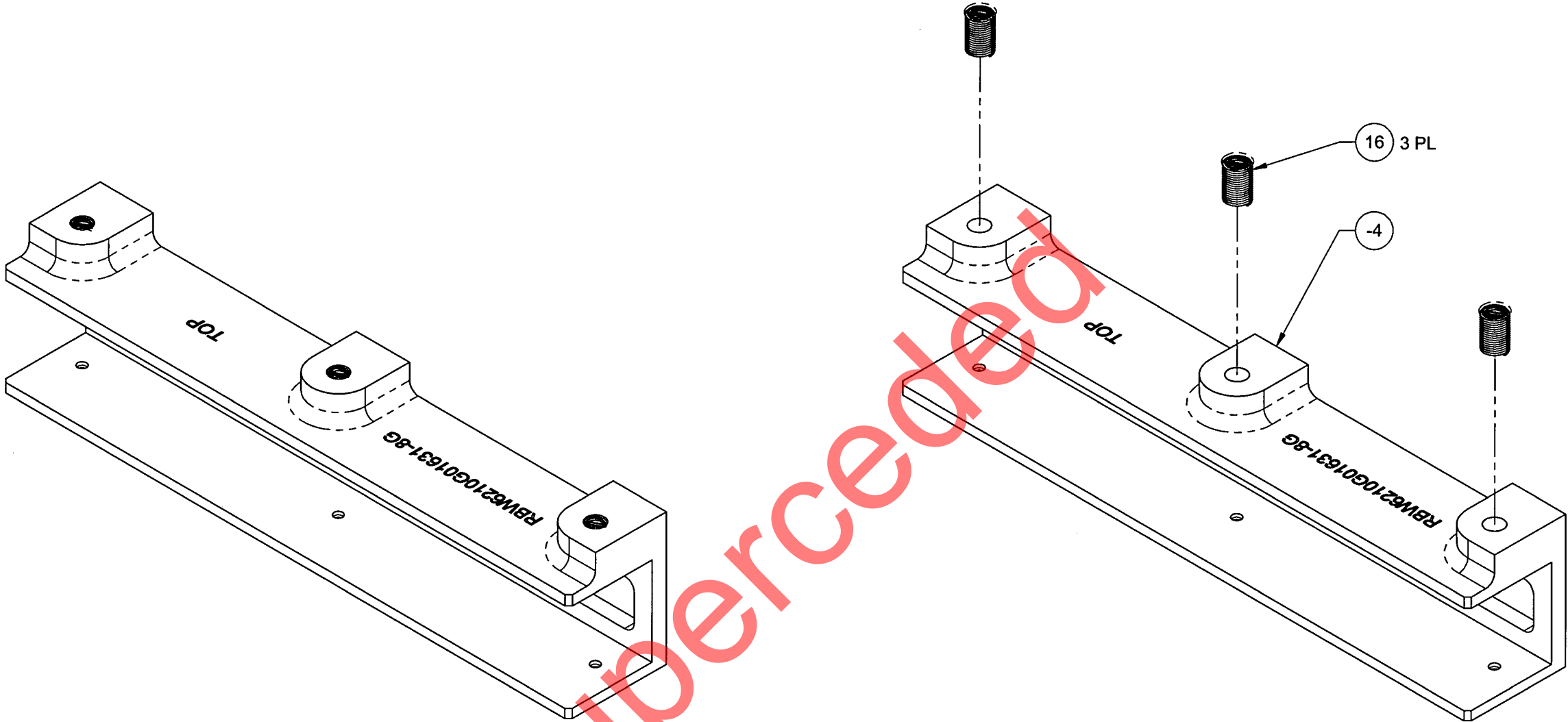
NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = $\pm 0.1"$ / $\pm 1^\circ$
X.XX = $\pm 0.01"$ / $\pm 0.5^\circ$
X.XXX = $\pm 0.005"$ / $\pm 0.1^\circ$
X.XXXX = $\pm 0.0005"$ / $\pm 0.05^\circ$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $\pm 0.005"$
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005" TO 0.010"
- 7) IDENTIFICATION: N/A

DESIGN	KPT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	FK	RBW6210G01631-8G	SHEET 2 OF 12
APPROVED	<i>[Signature]</i>	TITLE	SCALE
		M/R BLADE LOCKING PROTECTION TOOL	NTS
DATE 9/7/2018		COPYRIGHT © 2018 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUBJECT TO THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



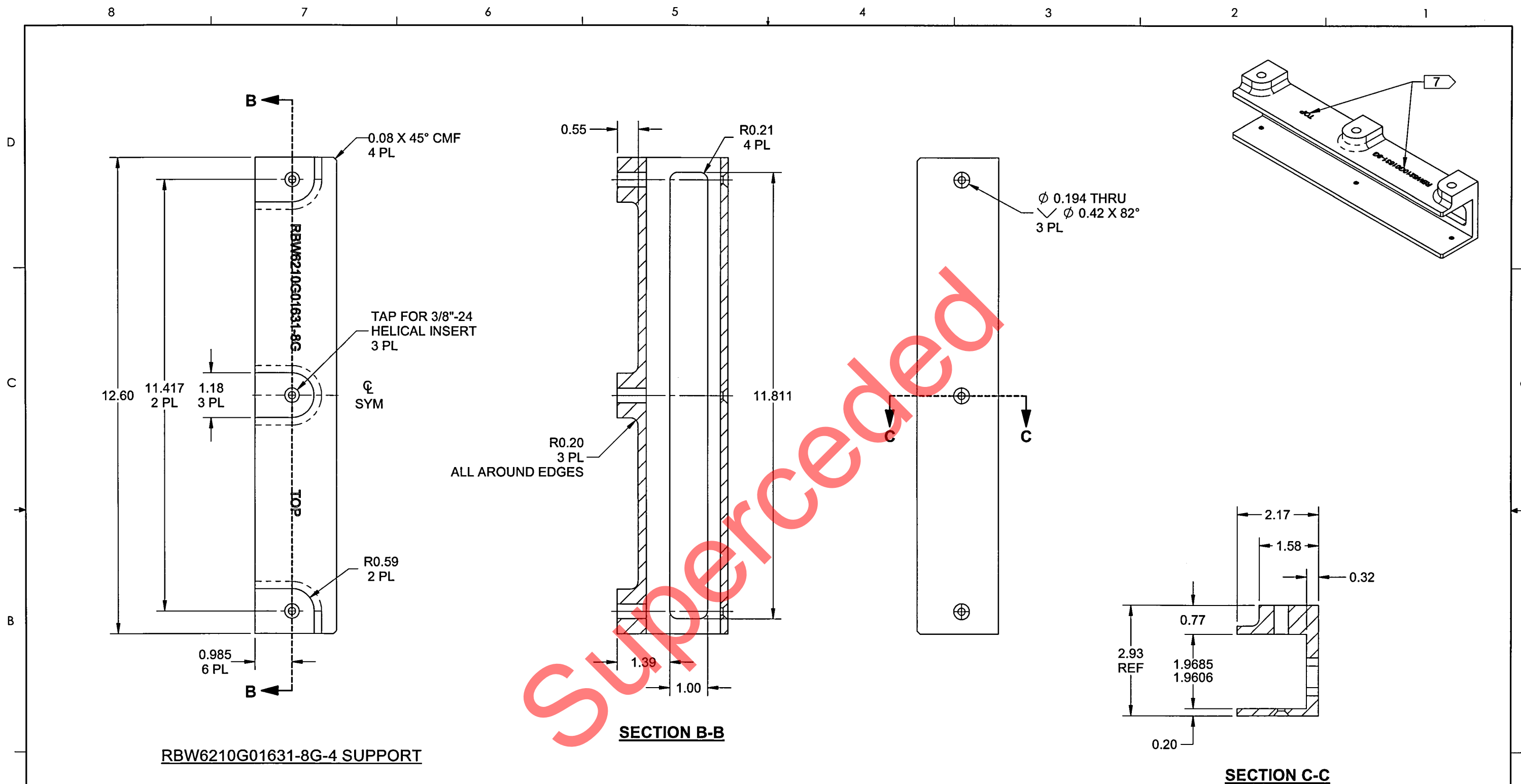
ITEM #	QTY	PART #	PART TITLE
-4	1	RBW6210G01631-8G-4	SUPPORT
16	3	McMaster#91732A749 OR EQUIV.	SS HELICAL INSERT 3/8"-24 X 3/4" LG.



RBW6210G01631-8G-3 SUPPORT ASSY

NOTES:
1) MATERIAL: N/A
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: N/A
7) IDENTIFICATION: N/A

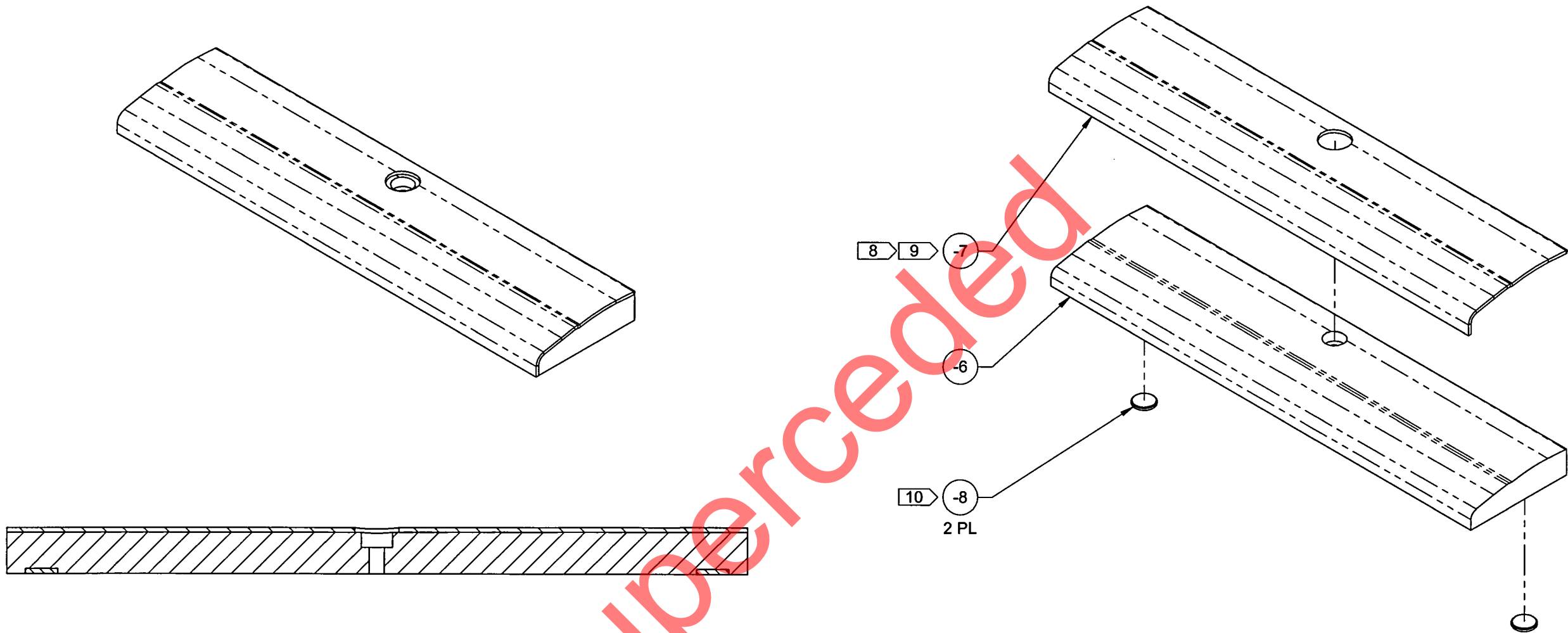
DESIGN	KPT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	FK	RBW6210G01631-8G	SHEET 4 OF 12
APPROVED	WY	TITLE	SCALE
DATE 9/7/2018		M/R BLADE LOCKING PROTECTION TOOL	NTS
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- NOTES:
- 1) MATERIAL: 6061-T6 / 7075-T6
 - 2) HEAT TREAT: N/A
 - 3) FINISH: ANODIZE RED PER MIL-A-8625 TYPE 2 CLASS 2
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: 0.005" TO 0.010"
 - 7) IDENTIFICATION: MACHINE ENGRAVE OR DOT MARK

DESIGN	KPT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	FK	RBW6210G01631-8G	SHEET 5 OF 12
APPROVED	VM	TITLE	SCALE
DATE 9/7/2018		M/R BLADE LOCKING PROTECTION TOOL	NTS
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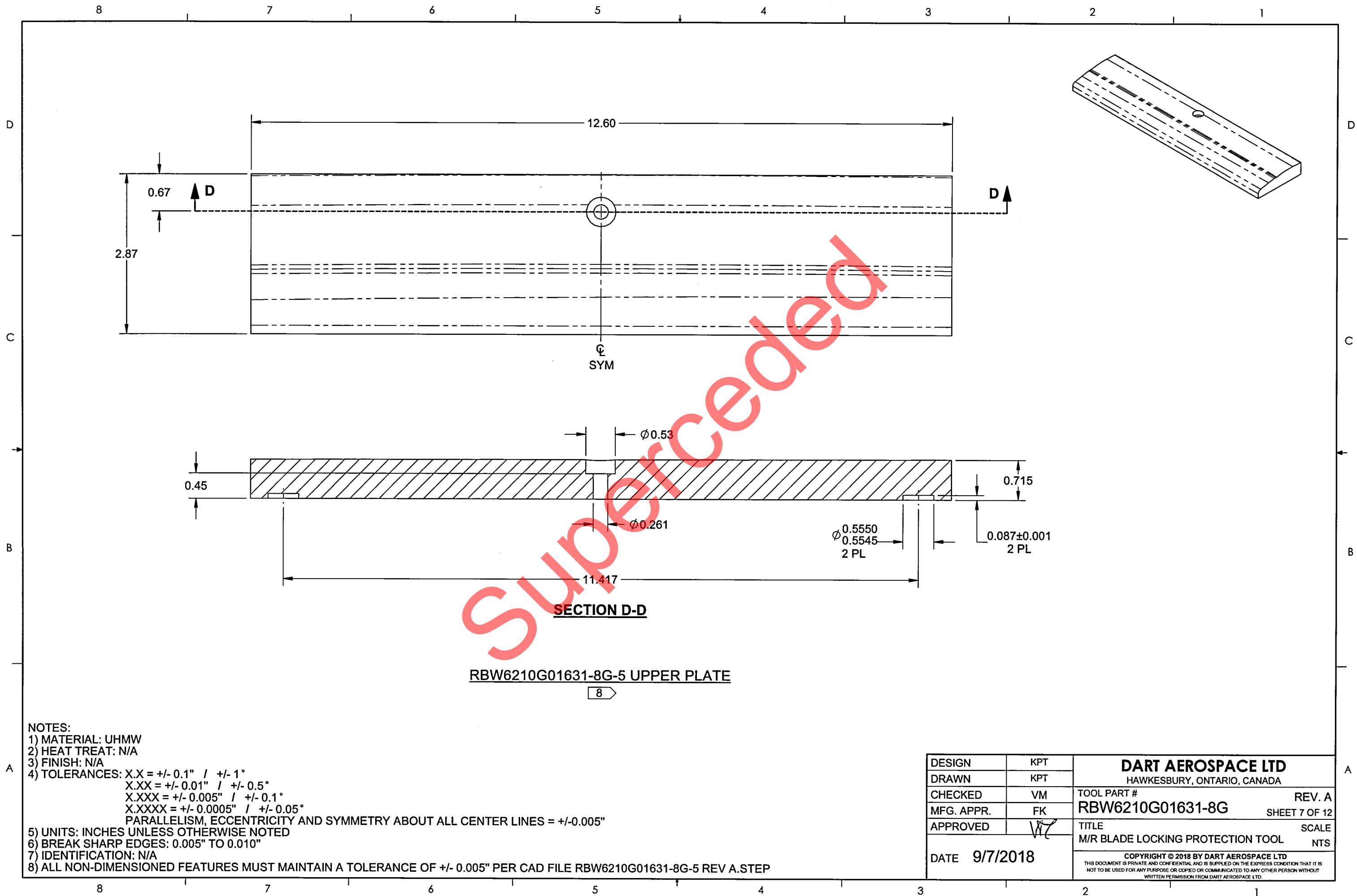
ITEM #	QTY	PART NUMBER	PART TITLE
-6	1	RBW6210G01631-8G-6	UPPER PLATE
-7	1	RBW6210G01631-8G-7	UPPER PLATE PROTECTION
-8	2	RBW6210G01631-8G-8	REACTION

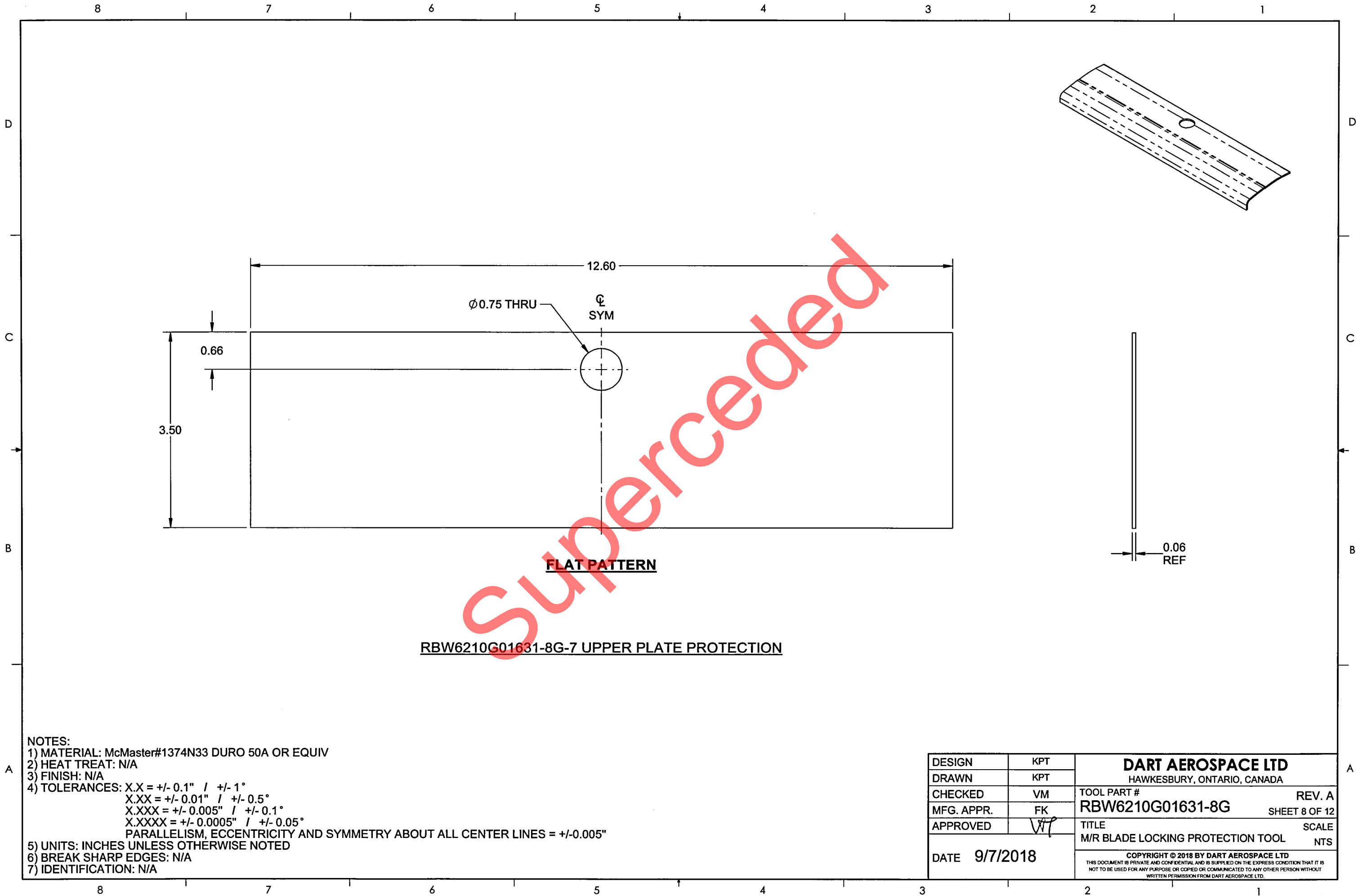


RBW6210G01631-8G-5 UPPER PLATE ASSY

- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: N/A
 - 7) IDENTIFICATION: N/A
 - 8) ASSEMBLE ITEM -7 ADHESIVE SIDE ON ITEM -6 AS SHOWN AND CUT EXCESS IF NECESSARY
 - 9) APPLY LOCTITE 495 BETWEEN THE SURFACES OF ITEM -7 AND ITEM -6 IF NECESSARY, AND REMOVE EXCESS
 - 10) APPLY LOCTITE 620 OR EQUIVALENT ON MATING SURFACES THEN PRESS FIT ITEM -8 WITH ITEM -6 AND REMOVE EXCESS

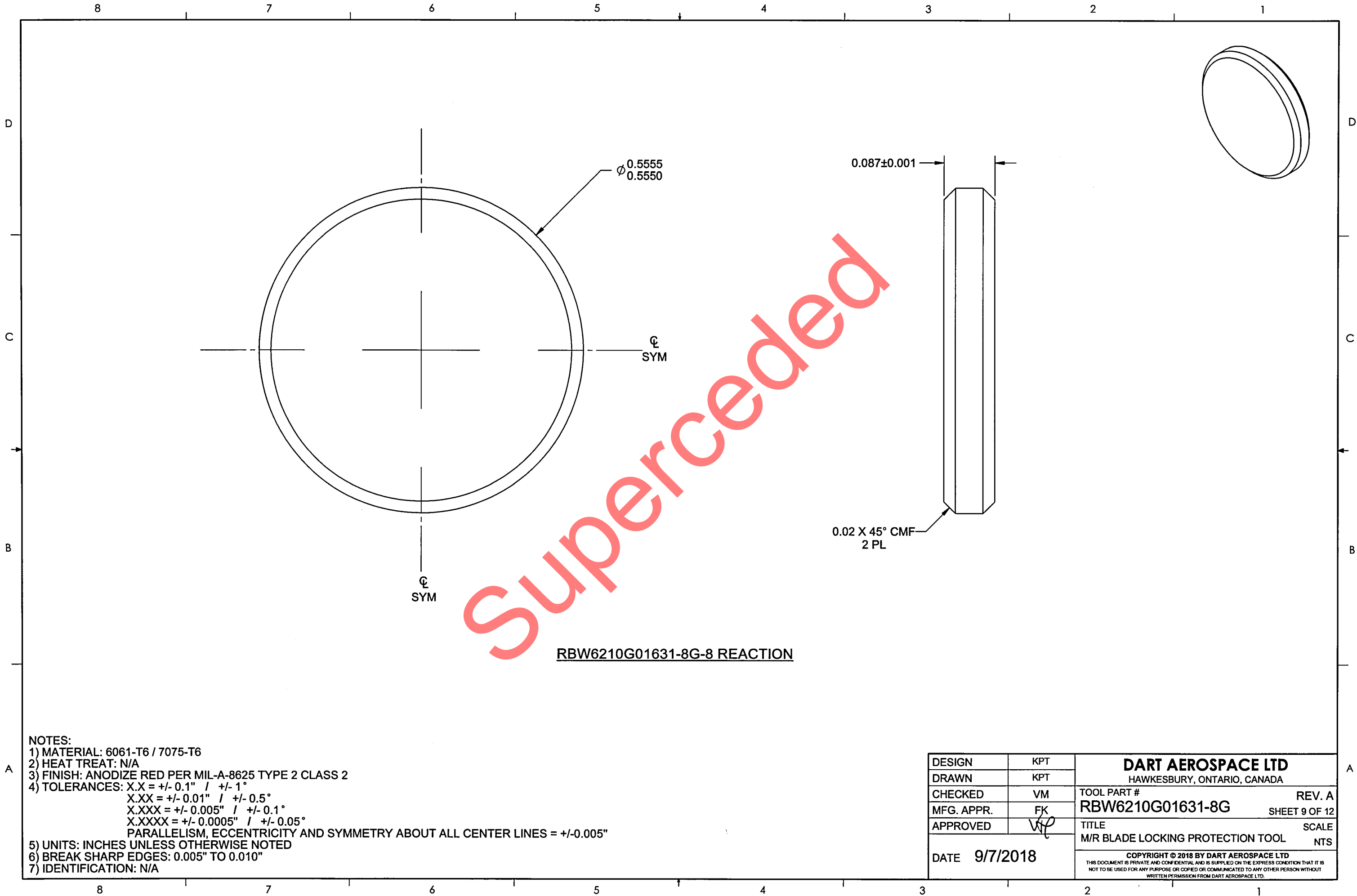
DESIGN	KPT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	FK	RBW6210G01631-8G	SHEET 6 OF 12
APPROVED	<i>VP</i>	TITLE	SCALE
DATE 9/7/2018		M/R BLADE LOCKING PROTECTION TOOL	NTS
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NOTES:
1) MATERIAL: McMaster#1374N33 DURO 50A OR EQUIV
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: N/A
7) IDENTIFICATION: N/A

DESIGN	KPT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	FK	RBW6210G01631-8G	SHEET 8 OF 12
APPROVED	VP	TITLE	SCALE
DATE 9/7/2018		M/R BLADE LOCKING PROTECTION TOOL	NTS
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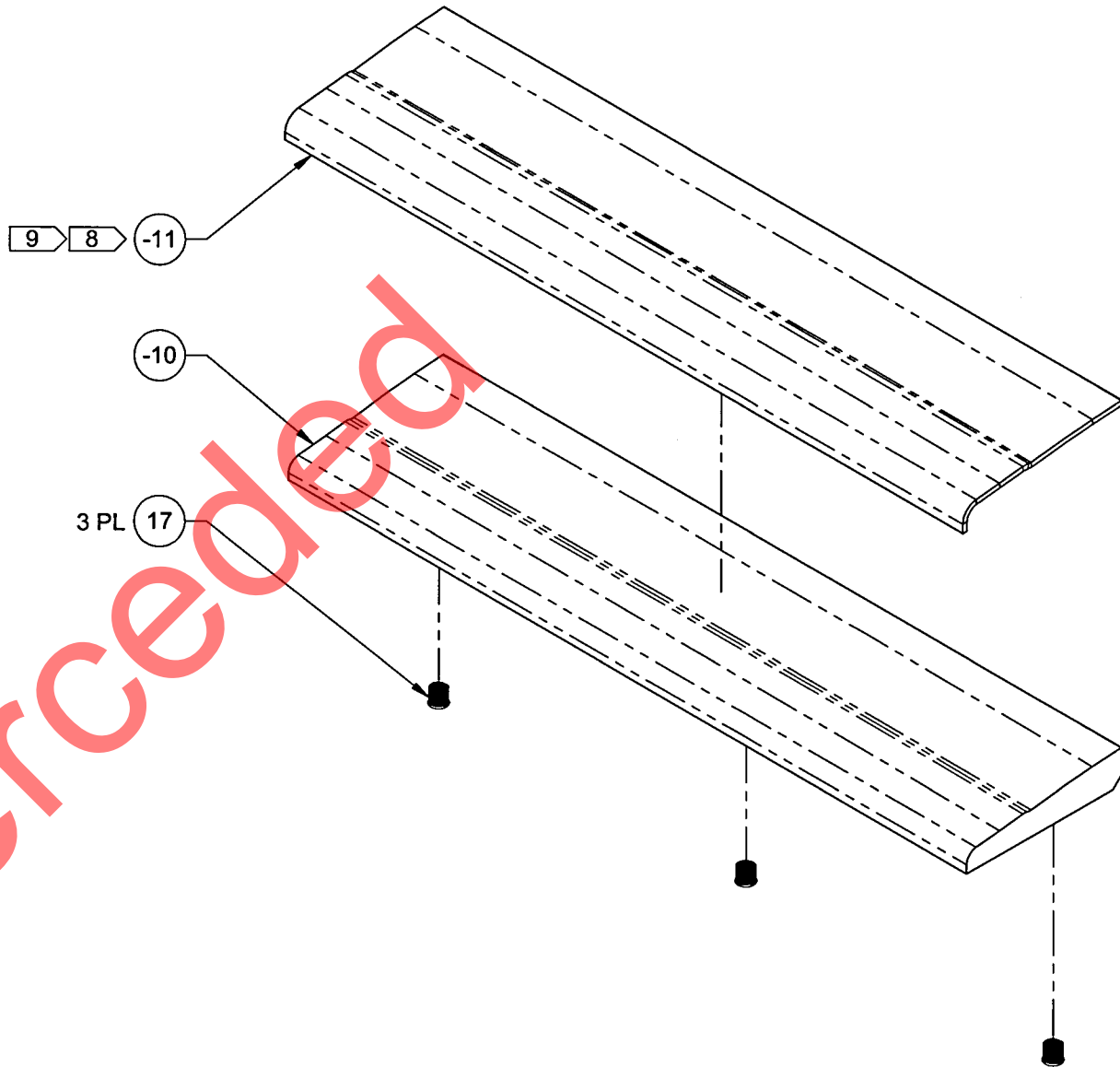
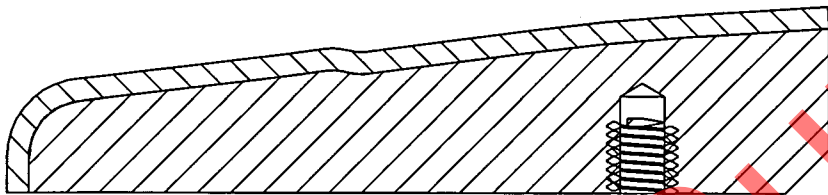
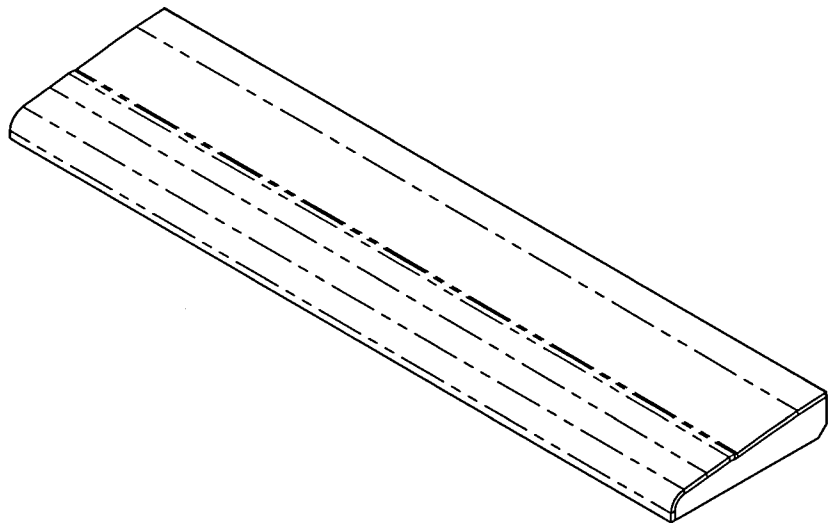


RBW6210G01631-8G-8 REACTION

- NOTES:
- 1) MATERIAL: 6061-T6 / 7075-T6
 - 2) HEAT TREAT: N/A
 - 3) FINISH: ANODIZE RED PER MIL-A-8625 TYPE 2 CLASS 2
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: 0.005" TO 0.010"
 - 7) IDENTIFICATION: N/A

DESIGN	KPT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	FK	RBW6210G01631-8G	SHEET 9 OF 12
APPROVED	VP	TITLE	SCALE
DATE 9/7/2018		M/R BLADE LOCKING PROTECTION TOOL	NTS
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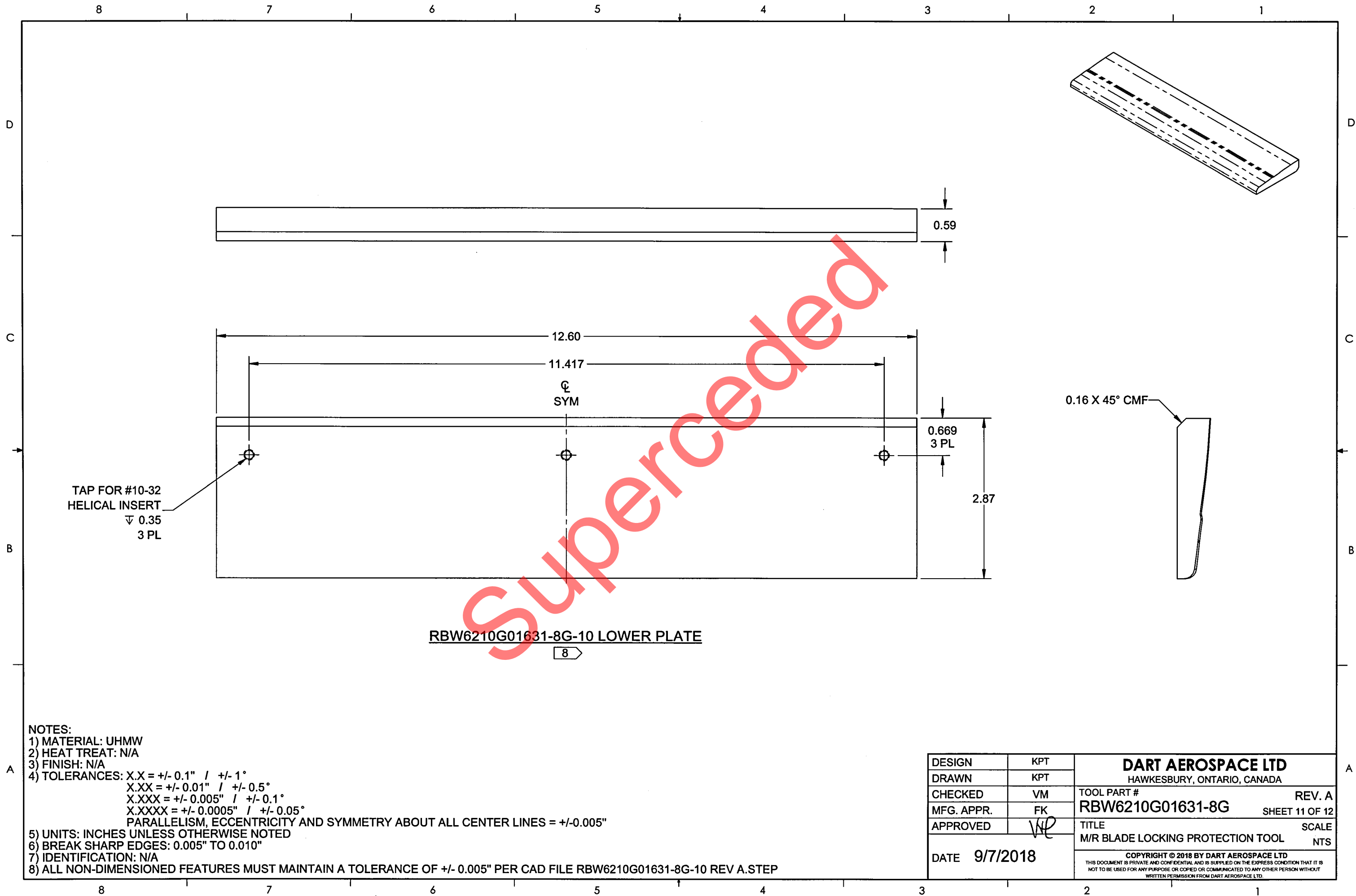
ITEM #	QTY	Part #	PART TITLE
-10	1	RBW6210G01631-8G-10	LOWER PLATE
-11	1	RBW6210G01631-8G-11	LOWER PLATE PROTECTION
17	3	McMaster#91723A231 OR EQUIV.	SS HELICAL INSERT #10-32 X 0.285" LG.

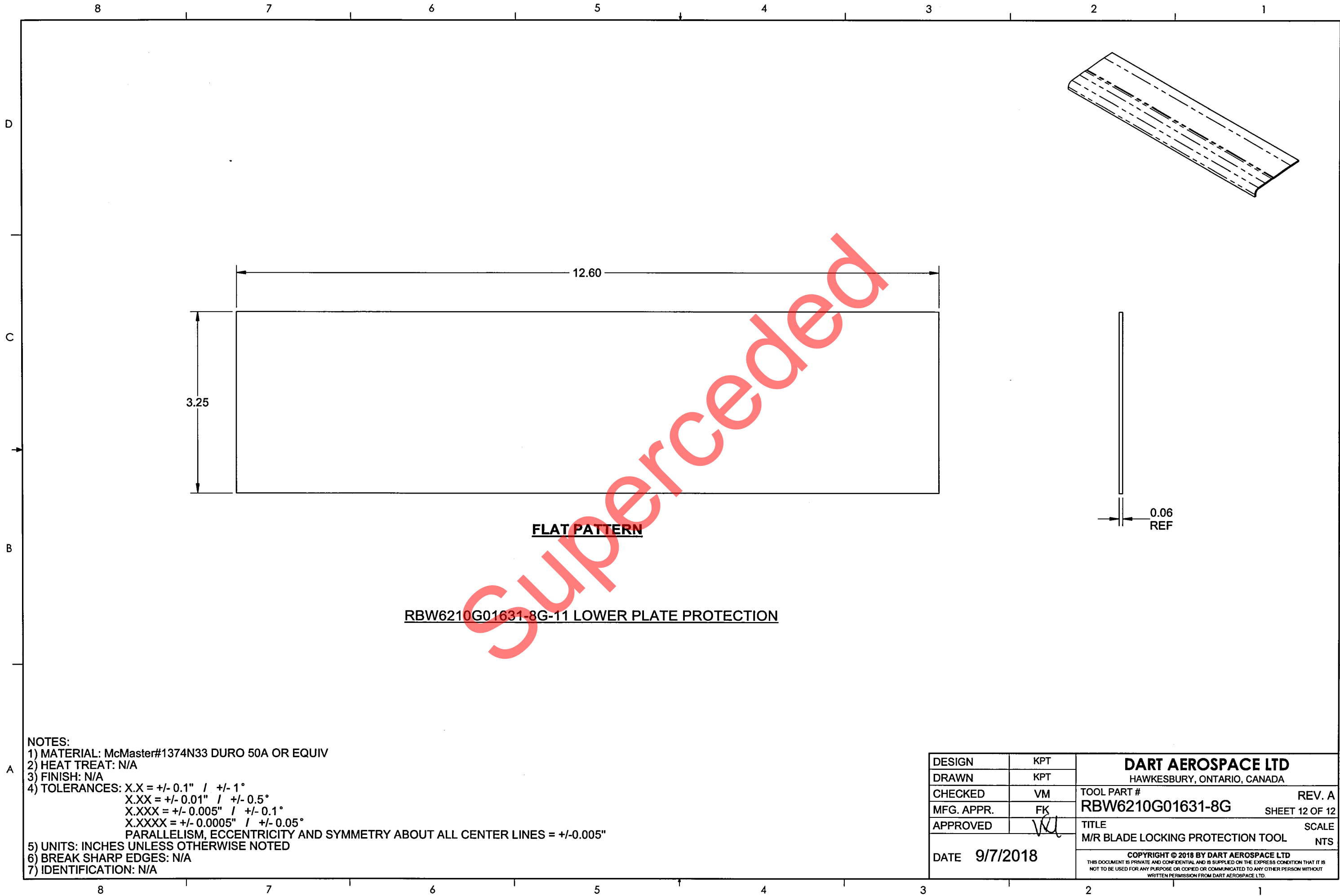


RBW6210G01631-8G-9 LOWER PLATE ASSY

- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: N/A
 - 7) IDENTIFICATION: N/A
 - 8) ASSEMBLE ITEM -11 ADHESIVE SIDE ON ITEM -10 AS SHOWN AND CUT EXCESS IF NECESSARY
 - 9) APPLY LOCTITE 495 BETWEEN THE SURFACES OF ITEM -11 AND ITEM -10 IF NECESSARY, AND REMOVE EXCESS

DESIGN	KPT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	FK	RBW6210G01631-8G	SHEET 10 OF 12
APPROVED	VM	TITLE	SCALE
DATE 9/7/2018		M/R BLADE LOCKING PROTECTION TOOL	NTS
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NOTES:
1) MATERIAL: McMaster#1374N33 DURO 50A OR EQUIV
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: N/A
7) IDENTIFICATION: N/A

DESIGN	KPT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	FK	RBW6210G01631-8G	SHEET 12 OF 12
APPROVED	<i>WJ</i>	TITLE	SCALE
DATE 9/7/2018		M/R BLADE LOCKING PROTECTION TOOL	NTS
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